

NCR-19-7732



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3723-20**Job Sheet 195066****Part No:** RBE350A93-3723-20**Job Qty:** 4 pcs**Part Name:** Seal Tool**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/13/19**Job Tracking No:****Due Date:** 7/2/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:** *order 11876***Note:** DWG RBE350A93-3723-20 Rev.A IPP Rev. A 18.10.22 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-2500Y - 1	4 pcs	7/2/19	7/2/19	0.00	4.00	SL-2500Y - 1		<i>SL 19-6-7</i>
120	QC 2	4 pcs	7/2/19	7/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		<i>SL</i>
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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130	QC 8	4 pcs	7/2/19	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 8 - 12	2019/06/08
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
150	Outsource - 13 - Zinc Plating	4 pcs	7/2/19		GRO002-VC	10 2019-06-11
160	Packaging 2-1 - Receive - B4B	4 pcs	7/2/19	0.00 0.00	Packaging 2 - 1 - B4B	JUN 17 2019
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	

				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170 QC 6	4 pcs	7/2/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
180 Packaging 3-1 - Stock - B4B	4 pcs	7/2/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - FG	4 pcs	7/2/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 110 - 1-Machine as per DWG. FC 310 FOLIO REV: AA DWG REV: A 2-Deburr
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 150 - -Issue P/O to Groupe Altech: P/O 43691 -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required
 160 - (Receive & Inspect for Damage & Mat'l Certs)
 170 - (QC6- All purchased or subcontracted products)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

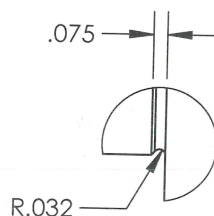
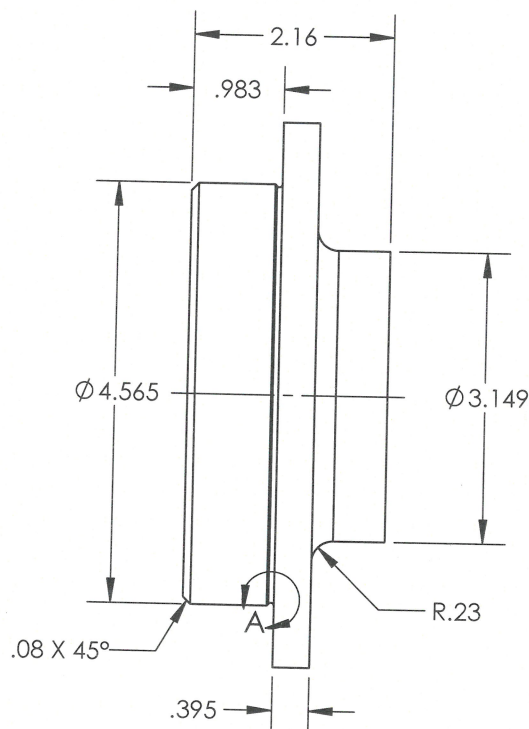
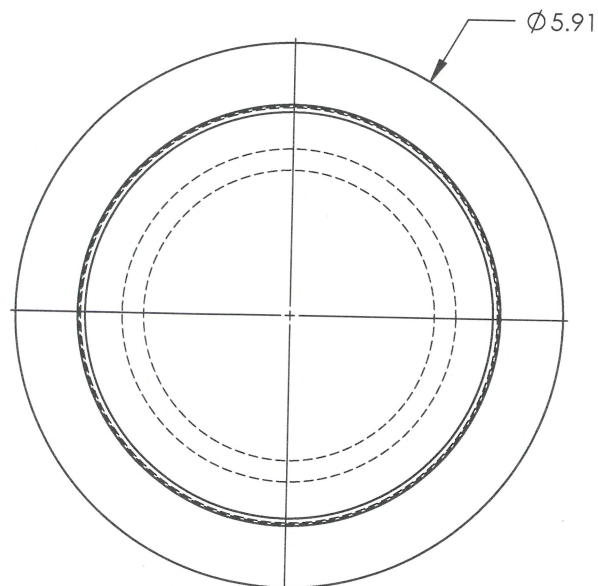
Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-R-6.000	Hot Rolled Steel Round Bar 6.000" Dia.	.8880 ft (.222 ea)	110-SL-2500Y - 1	123414

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-2500Y - 1	MT-HRS-R-6.000	1	2	0
Part Specifications				
Specifications could not be found.				

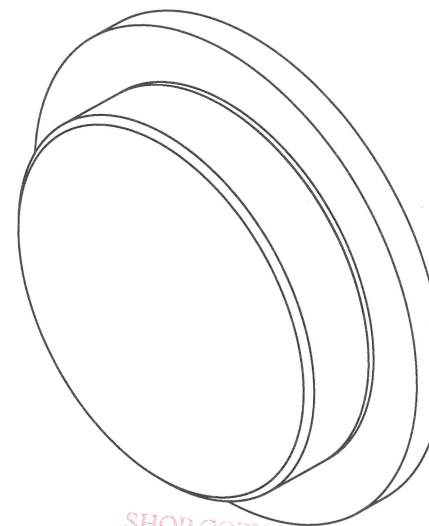
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
A	CH'D T/N WAS RBEA93-3723-20 IS RBE350A93-3723-20, CH'D FINISH WAS MIL-81562 CAD PLATE CLEAR IS QQ-P-416F, TYPE I, CLASS 1, CAD PLATE CLEAR.	6/6/2014	DJN
			RJC



DETAIL A
SCALE 1 : 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195066 M15

19-05-14

NOTE:

REF. EUROCOPTER T/N: 350A93-3723-20

RED BARN MACHINE	
TITLE SEAL TOOL	
DWG NO. RBE350A93-3723-20	
REV A	
MAT'L 1018	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED D. Weil
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH CAD PLATE CLEAR
.X ± .1	SPEC QQ-P-416F, TYPE I, CLASS I
ANGLES ± 5°	USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	EUROCOPTER 350A
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 6/6/2014
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	SEAL TOOL	1018	Ø6 X 2-3/8	



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043691



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043691

PO Date: 6/11/19

Due Date: 6/18/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-12

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195066	RBE350A93-3723-20	Seal Tool -Issue P/O to Groupe Altech: P/O _____ Zinc plate, ASTM B633 TYPE 1 SC2 ; Material 1018 - Certificate of Conformity is required	Firmed	-	6/18/19	4 pcs	0 pcs	4 pcs	\$9.00/pcs	\$36.00
					4 X	JUN 17 2019					
2	194436	RBE350A93-3717-00-03	Half Receiver (Outside Processing - Zinc Plating)-Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	6/18/19	6 pcs	0 pcs	6 pcs	\$9.00/pcs	\$54.00
					6 X	JUN 17 2019					
Grand Total:											\$90.00

DAS
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9-89



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PURCHASE ORDER

POHB043691



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/12/19 2:35 PM Dart.Guerin.Kimberley

**Certificat de Conformité / Certificate of Compliance**
(019928-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupealtech.com

Bon de Livraison / Packing Slip**019928- 1**

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
13-Jun-2019		SVETLANA DORZHIYEVA			POHB043691			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RBE350A93-3723-20 Rev. ✓	RBE350A93-3723-20 ZINC PLATE ASTM B633-TYPE 1 SC2	ZINC CH	4	4	0	0	0
2	RBE350A93-3717-00-03 Rev. ✓	RBE350A93-3717-00-03 ZINC PLATE ASTM B633 TYPE 2 SC2	ZINC CH	6	6	0	0	0

RECEIVED
JUN 14 2019
DART AEROSPACE LTD.

DAS
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9-89**Notes Additionnelles / Additional Notes****Epaisseur réelle
Actual Thickness****Inspecteur Qualité
Quality Inspector****Réçu par
Received By**

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

Entered: ZKDate: Nov 19/19NCR No. 19-7732

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>195066</u> Part No. <u>RBE350A93-323-20</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>06/17/2019</u>	Sequence #: <u>op. 120. QC</u>	QTY Affected: <u>4 of 4</u>		MRB (QSI042) <u>Mlee</u> JUNE 21/19	
Description Work Order Deviation <u>Finish inconsistent</u> Finish Reqt on Dwg. (Rev. A) Cad Plate Clear to QQ-P-416F TY1. CLI Actual: PO# POHB04369 / 2 CofC Zinc Plate to ASTM B633 TY1, SC2 AS PER PO Reqt.		Disposition A SURFACE FINISH OF ZINC PLATING PER ASTM B633 TYPE 1 CLASS 2 IS ACCEPTABLE. NO CHANCE TO FIT FORM OR FUNCTION.		Completed By Lead hand / Supervisor QC / QA Coordinator <u>D 19.11.01</u>	
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☒ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					